



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5622-5

Job Sheet 196585



Part No: D5622-5

Job Qty: 4 pcs

Part Name: 429 - AFT Wearpad - OEM Replacement - Standard - LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/17/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/19/19

Type: Stock

Description: 5109

Note: DWG D5622 REV.B IPP REV:A NEW ISSUE 18/05/16 JFS VERIFIED BY:DD IPP REV:B 18.11.26 AS PER
DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Waterjet - Flow - 1	4		7/19/19	0.17	0.25	Waterjet - Flow			06/19/10/29
		pcs								
120	QC 2	4		7/19/19	0.00	0.00	QC 2 - 1			06/19/10/29
		pcs					QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 86			
							QC 2 - 84			

RT

SPACE

o: S227884



-5

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atch: S227884

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 813 632-5200

Email: sales@dartaero.com

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arlous STC's

Date: 11/08/19



Container No: S227884



Part: D5622-5

Job No: 196585

Serial No/Batch: S227884

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
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Date: 11/08/19

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130 QC 8	4 pcs	7/19/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Small Fab - Brake NC - B4B	4 pcs	7/19/19	0.25 0.03	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	NOV 05 2019
150 QC 5	4 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160 Automated Welding - B4B	4 pcs	7/19/19	0.00 0.13	Automated Welding - 1 - B4B	NOV 05 2019
170 QC 10	4 pcs	7/19/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	

180 QC 5	4 pcs	7/19/19	0.00 0.00	QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	2
				QC 5 - 30	
				QC 5 - 40	
190 Handfinish - 4-1-Assembly-B4B	4 pcs	7/19/19	0.00 0.11	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	DAS
				Handfinish - 4 - 12 - B4B	41 NOV 11 2019
				Handfinish - 4 - 13 - B4B	3-89
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
200 QC 3	4 pcs	7/19/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	DAS
				QC 3 - 9	NOV 11 2019 68
				QC 3 - 40	9-89
				QC 3 - 19	
				QC 3 - 43	
210 Packaging 3-1 - Stock - B4B	4 pcs	7/19/19	0.00 0.00	QC 3 - 24	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220	QC 21 - SA	4	7/19/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53
					NOV 12 2019
					DAS 70
					9-89

Part Op 110 - 1-Cut D5622-5F as per Dwg D5622 Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Form as per dwg
 150 - QC5- Inspect part completeness to step on W/O
 160 - Automated welding - ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: 14139018
 170 - QC10- Inspect visual per QSI004- ground welds)
 180 - QC5- Inspect part completeness to step on W/O
 190 - Assemble as per dwg - APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG AND QSI BATCH: 14139018-5217452
 200 - QC3- Inspect Part Finish
 210 - Identify as per dwg & Stock Location: _____ LOCATION : FP001
 220 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.8920 sf (.223 ea)	110-Waterjet - Flow - 1	<u>5200442</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	1	295	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐				DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐								Date : _____ Sequence #: _____		QTY Affected : _____ Disposition		MRB (QSI042)	
Description Work Order Deviation						Completed By													
Lead hand / Supervisor						QC / QA Coordinator													

Root Cause		FAULT CATEGORY									
Operator	☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Outside Tolerance	☐
Manufacturing Process	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Drawing	☐		
Equip/Tooling	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Finish	☐		
Handling/Preservation	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Lost/Missing	☐		
Material	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Misread	☐		
Product Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐				
Process Improvement	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐				
Human Factors	☐	Other/Details:									